

Date: Monday, 02/06/2008 4:39:06 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	350/212/130 BASKET LID
Job Number :	39653B		
Estimate Number :	10193		
P.O. Number :		Part Number :	D2512
This Issue :	02/06/2008	Drawing Number :	D2512 UNDER REVIEW <i>At 03.06.03</i>
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	D2
Previous Run :	39652B	Material :	
Written By :		Due Date :	15/06/2008
Checked & Approved By :	<i>JUL 08.06.02</i>	Qty:	1 Um: Each
Comment :	Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W



✓
Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: *M108153**0.065 At 03.06.03**SAD**08/06/13**(P)*

2.0	D31663	Basket Hoop
-----	--------	-------------



✓
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3166-3

Basket Hoop

*B 38780**SAD**08/06/16**(P)*

3.0	D2506	Label Plate
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2506

Label Plate

*B37746**FC**08 06 23*

4.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-1

Bushing

*B36920**FC**08 06 23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/06/2008 4:39:06 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 39653B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
2 D2232-1 Hinge plate

Batch

35684

✓ FC 08 06 23

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
2 D2581 Mounting Bracket

Batch

1739046

✓ FC 08 06 23

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description Batch
18 sf M304EX0.75-16F Expanded Metal

M107966

SAD

08/06/19

①

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

FC

2-Cut (4) D2236 From D3166-3

SAD

08/06/16

①

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

FC

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

FC 08 06 23 ①

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-06-23 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/06/2008 4:39:06 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 39653B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

808/06/24 (X)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref 4.851) as per QSI 005 4.3

START TIME:

6:35

OVEN TEMPERATURE:

400°

FINISH TIME:

7:05

Coat 2

7:15

400°

7:45

FL 08/06/25

①

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M107893 FL 08-06-25

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CP 08/06/26 (X)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

CP 08/06/26 (X)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/01

Job Completion



MF 08-06-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

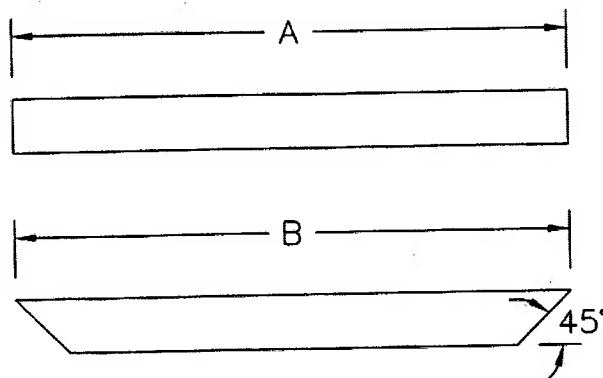


DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074	
D	01.04.19	CHANGE HINGE	
D1	UP 03.01.20	ADD D2012-117 FOR D130-701-041	
D2	UP 04.09.20	TACK WELD ANT-SKID AREA	

RELEASED
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



03.06.03
UNDER REVIEW
08.02.05 #
TUBING TO BE
CHANGED TO 0.065
WALL

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39653B

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST 0.065 Pd 03.06.03
MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X (0.060) WALL SQUARE TUBING
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

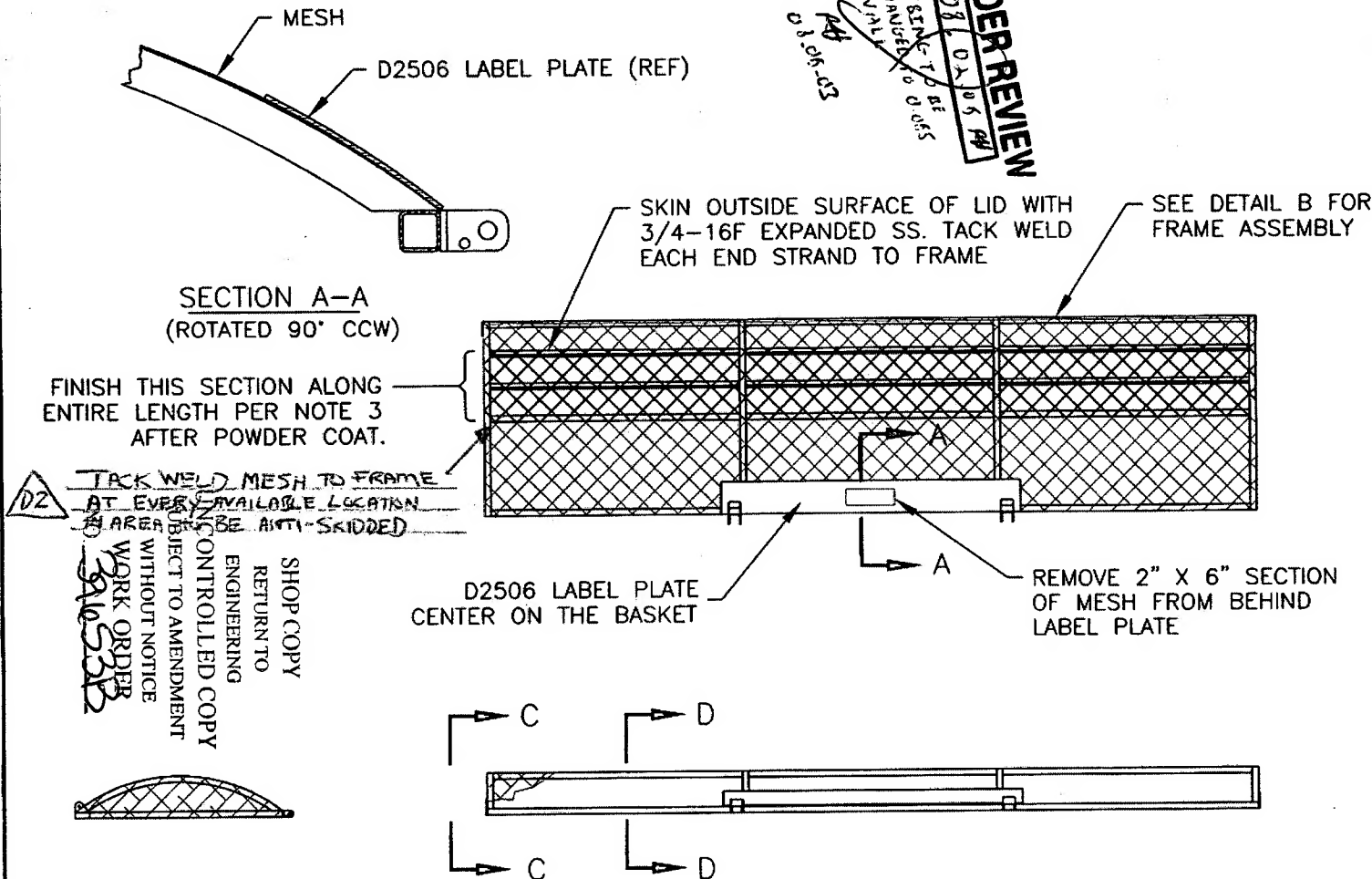
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DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	C	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D2512
DATE	TITLE	REV. D
01.04.19	BASKET LID ASSEMBLY (350/212)	SHEET 2 OF 4
		SCALE 1:20

UNDER REVIEW
08.02.05
TUBING TO BE
CRUSHED TO 0.065
WALL
08-05-03



D2512 BASKET LID ASSEMBLY

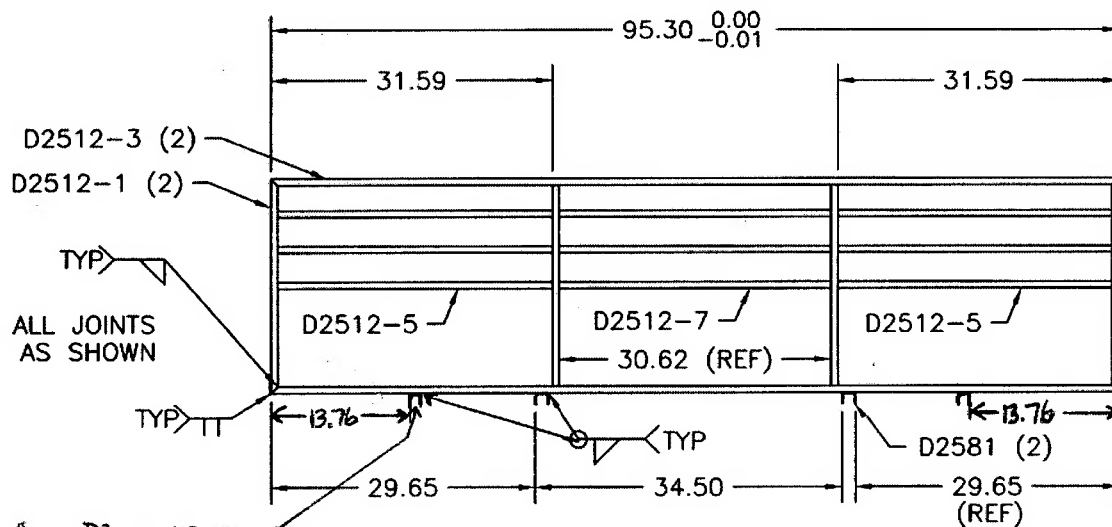
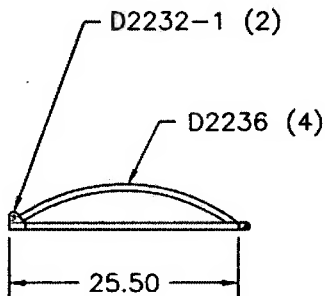
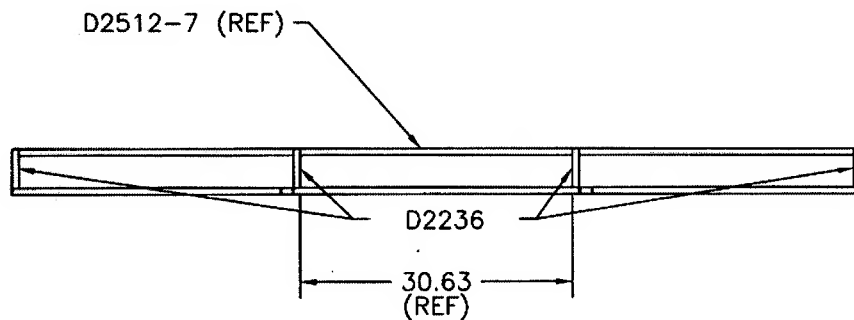
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED
01.04.21

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WORK ORDER
310535



DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	UP	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2512	SHEET 3 OF 4
DATE	TITLE	SCALE	
01.04.19	BASKET LID ASSEMBLY (350/212)	1:20	



WELD ALL JOINTS
AS SHOWN

D2012-117 CLEVIS
ADD FOR D130-701-041
ONLY (2 PLACES)

DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

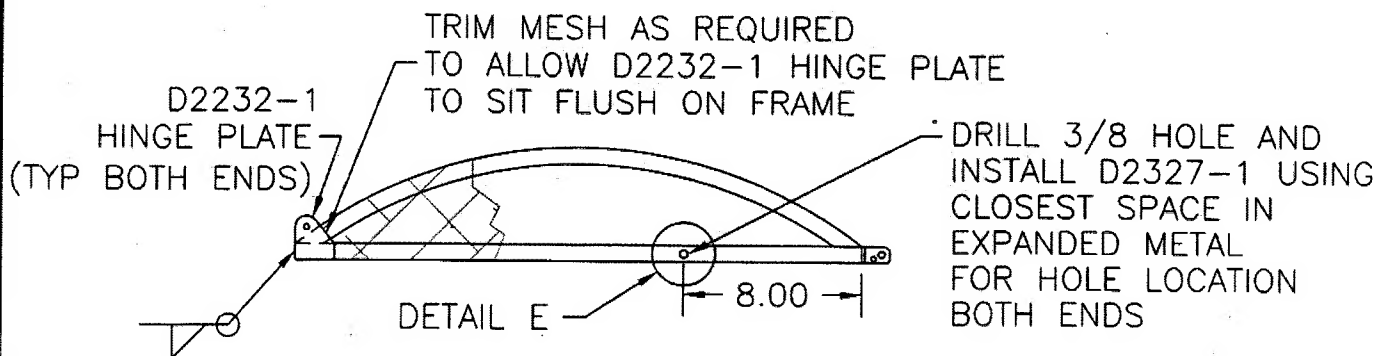
UNDER REVIEW
08.04.05
TUBING TO BE
CHANGED TO 0.065
WALL
Pdt 08.06.03

RELEASED
01.04.27
WORK ORDER
39105338

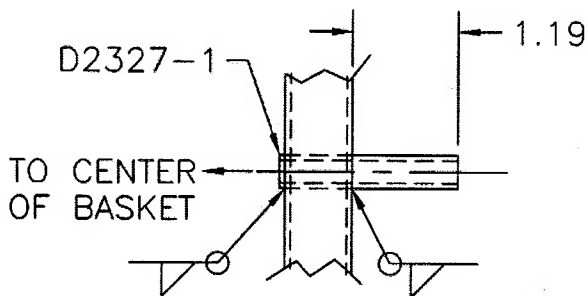
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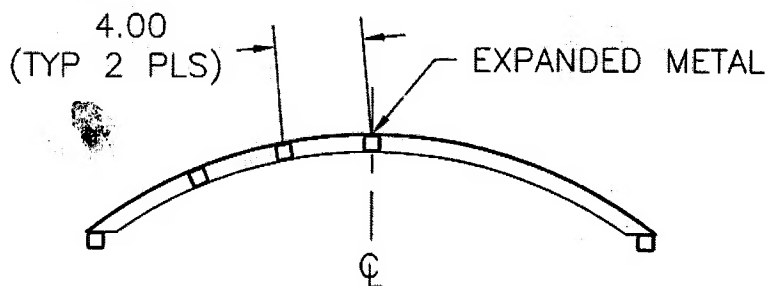
DESIGN	BW	DRAWN BY	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE	01.04.19	TITLE BASKET LID ASSEMBLY (350/212)			SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

PH 08.06.02
UNDER REVIEW
08.02.05 PH
TUBING TO BE
CHANGED TO 0.065
WALL

RELEASED
01.04.27

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